

Date: Tuesday, 10/02/2009 3:06:22 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 45688	
Estimate Number : 11641	
P.O. Number :	
This Issue : 10/02/2009 S.O. No. :	Part Number : D2990042 - 2 u
Prsht Rev. : NC	Drawing Number : D2990 REV B
First Issue : // Type : SMALL /MED FAB	Project Number : N/A
Previous Run : 33597	Drawing Revision : B
Written By :	Material :
Checked & Approved By : <u>JUD 09.02.10</u>	Due Date : 23/02/2009 Qty: 2 Um: Each
Comment : Est B 05.02.22 Revised Step 6 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28052	Stop
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

STOP

Pick:

Qty Part Number	Description	Batch
1 D2805-2	Stop	B46314

09/03/19

2.0	D29902	Bracket
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty Part Number	Description	Batch
1 D2990-2	Bracket	345789

09/03/19

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2990

09/03/19 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09/03/19

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

NA Alodine only

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:06:23 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 45688

Part Number: D2990042 - 2

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	_____

8.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	_____

N/A

9.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch	
4	NAS1515H3	Washer	_____	_____

A/R LPS-3

Corrosion Spray

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2990

Assemble as per Dwg D2990.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 45688

Part Number: D2990042 - 2

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: (SU)

9/4/15

(2x)

SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



MF
09-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

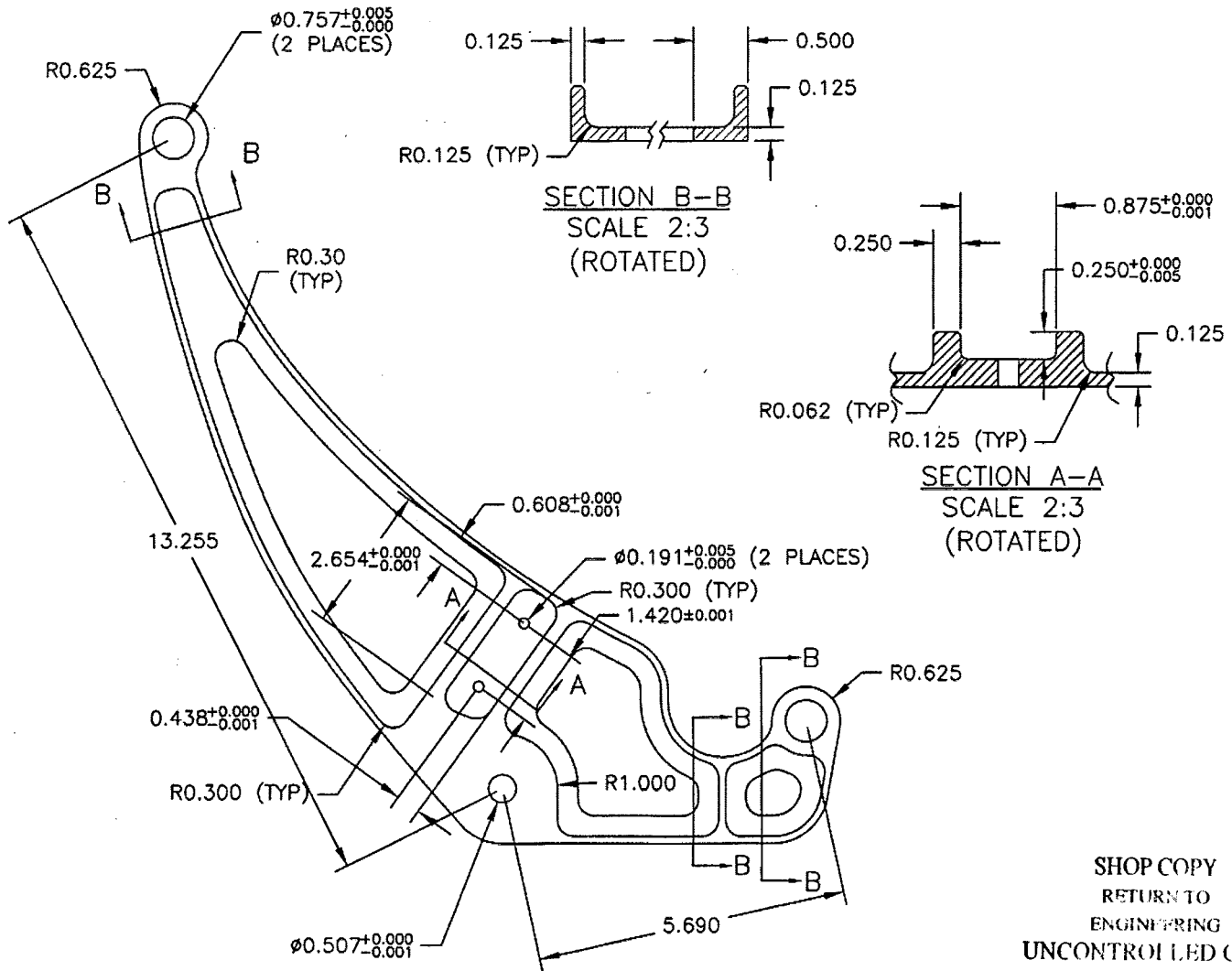
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2990	REV. B SHEET 1 OF 2
DATE 05.01.20	TITLE STA 129 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	05.01.20	ADD CUTOUTS & -043/-044	

RELEASED05.03.11 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45688*

D2990-1 BRACKET (SHOWN). D2990-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2990.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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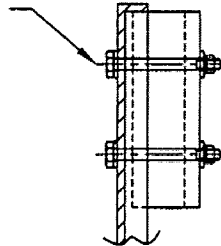
DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21	TITLE STA 129 BRACKET		SCALE 1:3

RELEASED

05.03.11 #

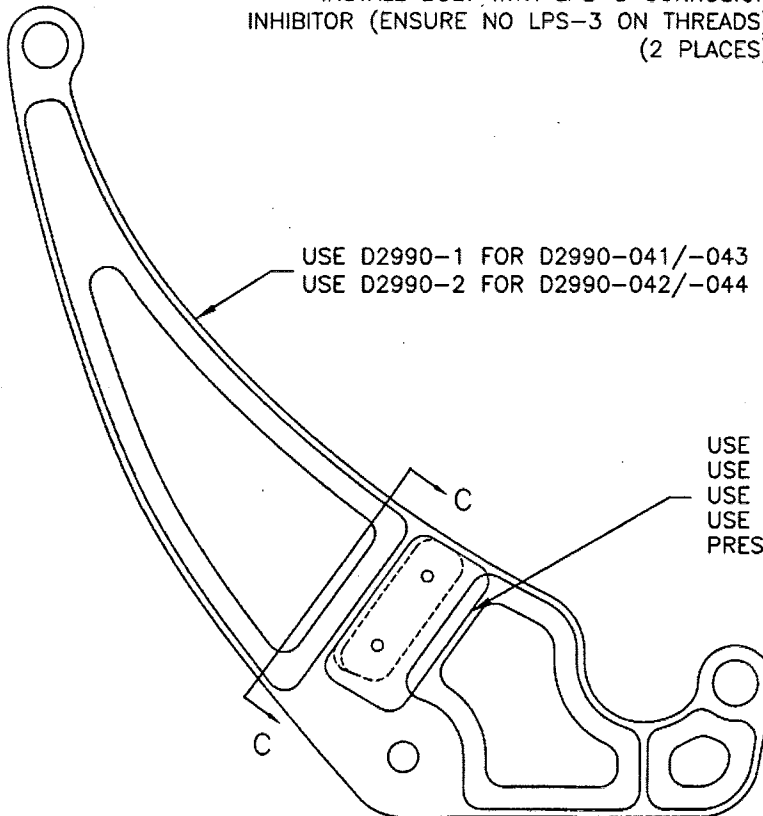
AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



USE D2990-1 FOR D2990-041/-043
USE D2990-2 FOR D2990-042/-044

SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 456083

D2990-041/-043 BRACKET ASS'Y (SHOWN).
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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